

SPLIT

Dart Aerospace Ltd.

Date: Friday, 5/25/2007 8:36:55 AM
User: Kim Johnson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 32649-2	
Estimate Number : 10288	
P.O. Number : N/A	Part Number : D25771
This Issue : 5/25/2007 S.O. No. : N/A	Drawing Number : D2577 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 31212	Material : N/A
Written By : <u>07.05.08</u>	Due Date : 6/12/2007 Qty: 30 Unit: Each
Checked & Approved By : <u>07.05.08</u>	
Comment : Est: E 02.09.24 Re-format, Incorporated D2577-101-11 K	
J/R/F	
est: F 06.09.11 now waterjet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
	Comment: Qty: 0.8474 sf(s)/Unit Total: 25.4205 sf(s) 1010/1025/A21/6aA SHEET	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D2577 (D2577-101 detail) Dwg Rev: <u>E</u> Prog Rev: <u>E</u> 2-Deburr if necessary <u>SAD 07/07/05</u> (9) <u>SAD 07/06/14</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SAD 07/06/14</u>	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK <u>07.06.14</u> (9)	
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE 1-Form on brake as per Dwg D2577 using DT8155 and DT8179 <u>SAD 07/07/17</u> (9) 2-Form joggle as per Dwg D2577 using DT8157 <u>SAD 07/07/18</u> 3-Identify as D2577-1 4-Deburr if nesasary <u>SAD 07/02/05</u> (9)	

9

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 32649

Part Number: D25771

Job Number:



Seq. # Machine Or Operation: Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

on 5/27/18 (19) counted

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

A/R 7560 Hardcoat Rod

Batch

M104721

88 07/07/19

88 07/07/19

(EX)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

(PTO) on back
10/07/20 (8)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m 104846

Biz/m 07-09-25 (8)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/7/25 (8)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-15

m 07/07/25
07/02

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/26

Job Completion



07/07/26

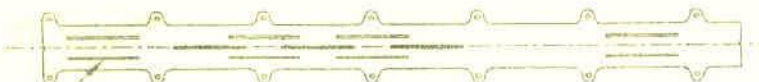
DART



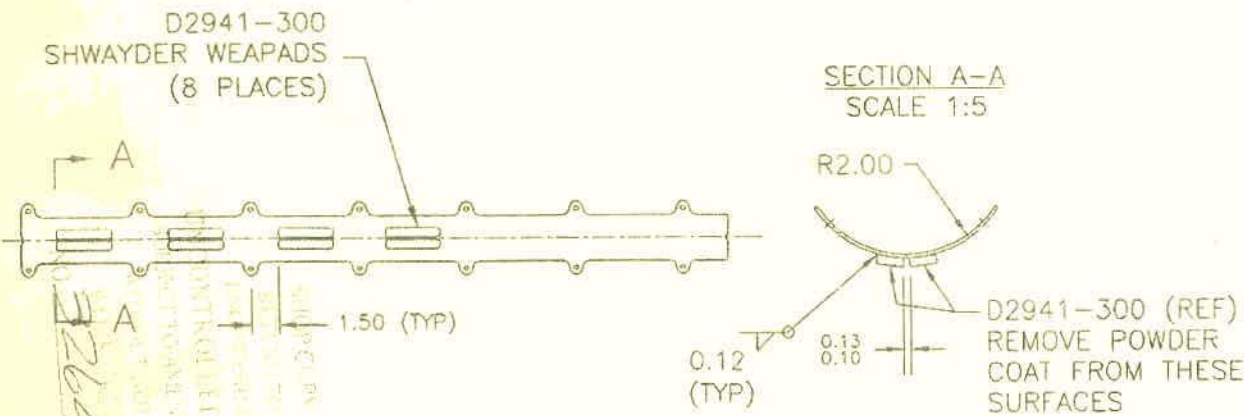
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DESIGN	DRAWN BY	DRAWING NO.	REV. E
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2577	SHEET 1 OF 5
DATE	TITLE	SCALE	
00.09.22	WEARSHOE	1:10	
A	96.09.16	NEW ISSUE	
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO OBOUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

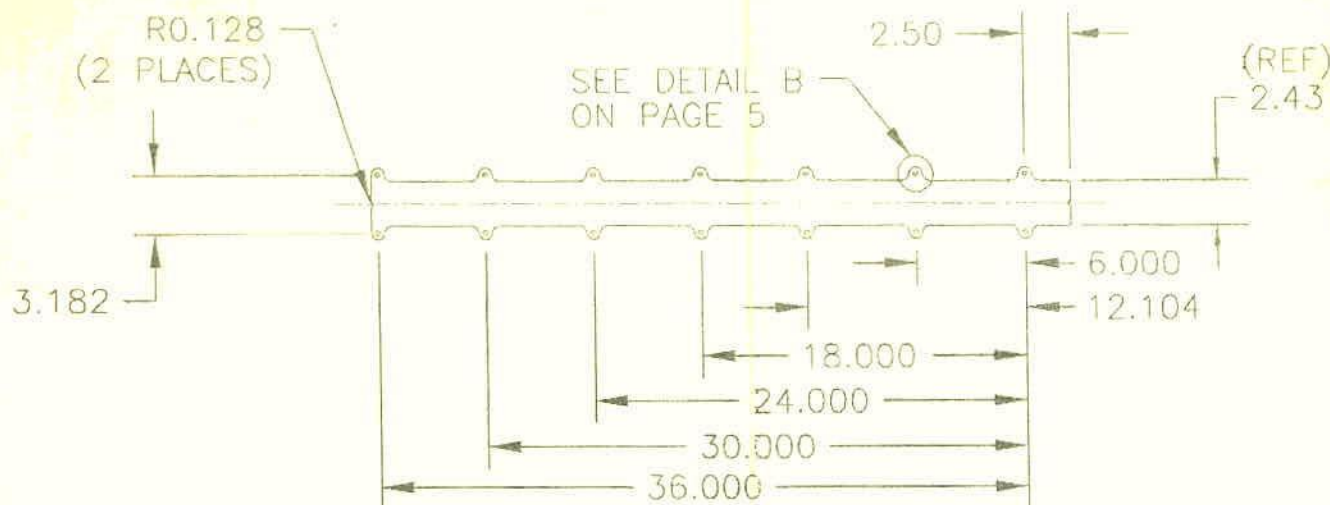
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<i>[Signature]</i>	<i>[Signature]</i>	D2577	SHEET 2 OF 5
CHECKED	APPROVED	TITLE	SCALE
<i>[Signature]</i>	<i>[Signature]</i>	WEARSHOE	1:10
DATE			
00.09.22			

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HAWKESBURY, ONTARIO, CANADA

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2004 26



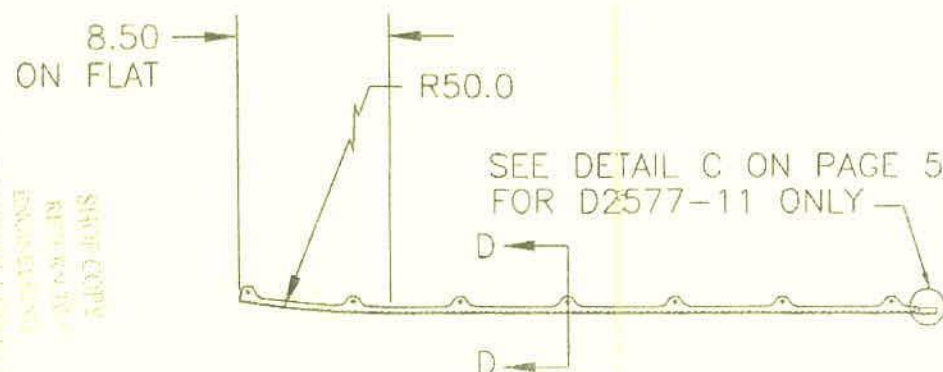
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

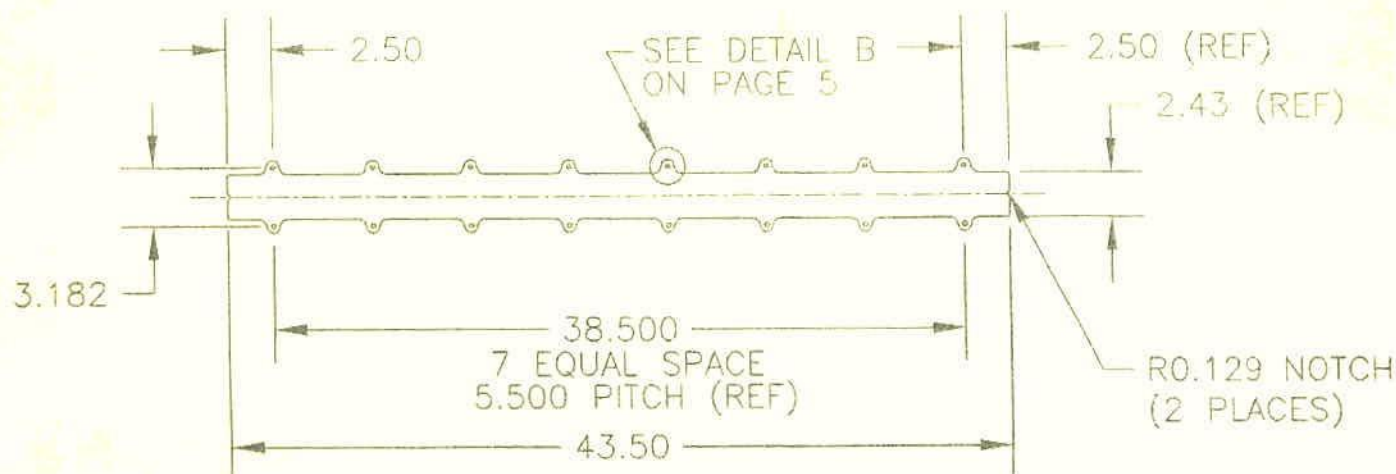
SHARP CORNER
R0.128
ENCLOSURE
UNCONTROLLED
SUBJECT TO APPROVAL
WITHIN 1 MONTH
NO. 33649

DART

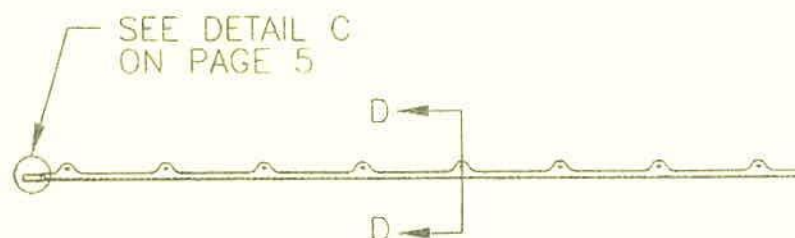


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DATE	00.09.22	TITLE	D2577	REV E
			WEARSHOE	SHEET 3 OF 5
				SCALE 1:10

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (1.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

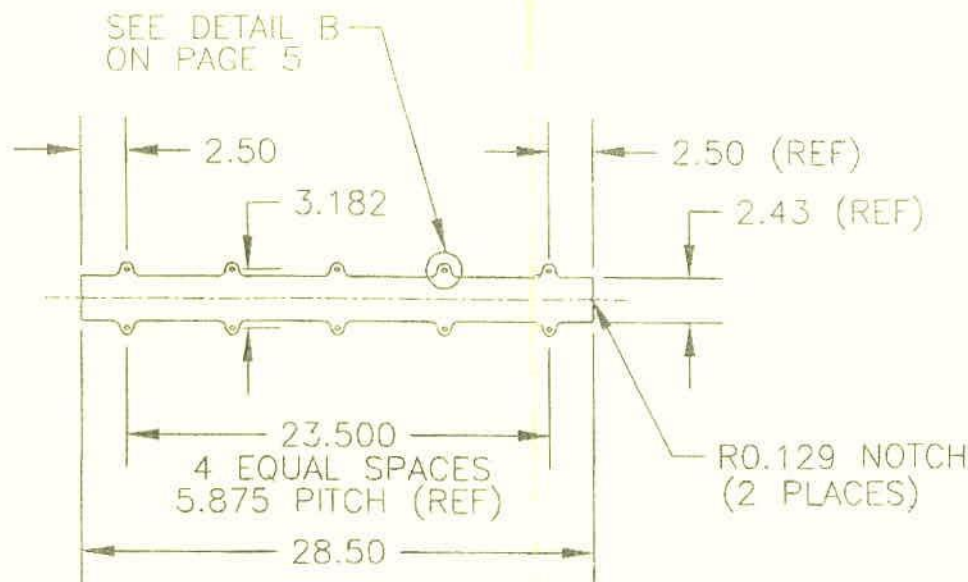
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427 8010
ENCLOSURE
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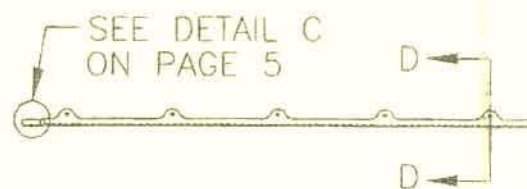


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00.09.22	D2577	SHEET 4 OF 5
	TITLE	SCALE
	WEARSHOE	1:10

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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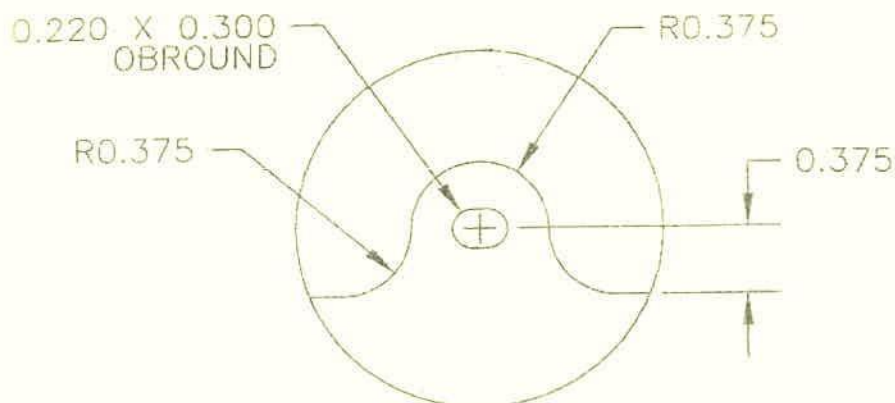
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ENGINEER NO
DNC FOR ROLLING COPY
SUBMIT TO APPROVING
WORKING NOTICE
DATE 00.09.22
32649



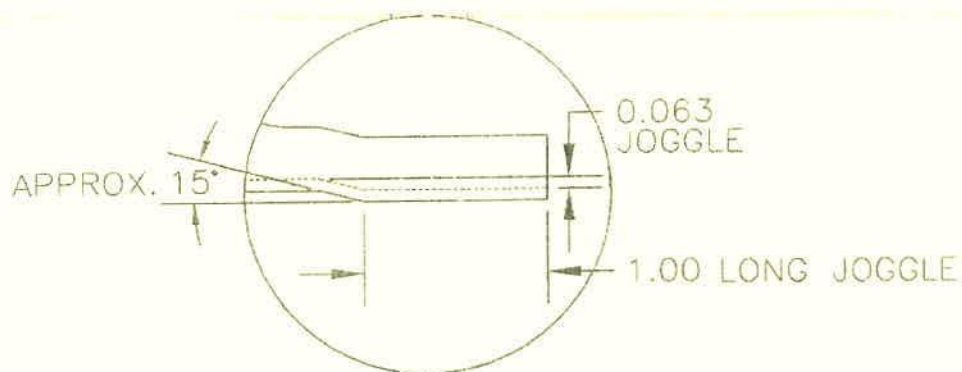
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DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

DETAIL B (SCALE 1:1)

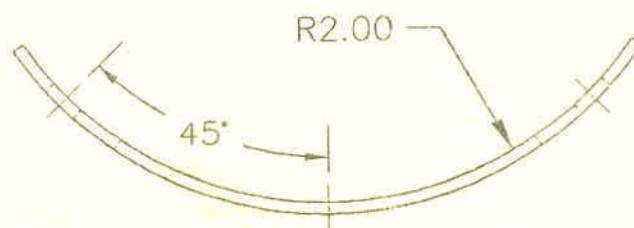
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DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



NO. 32649

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Work Order: 32649

Part Number: D25 771


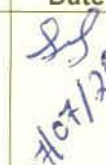



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Revised by	Approved
KJRF	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 12577-1 PAR #: N/A Fault Category: Prod/L.G NCR: Yes No DQA: Yes Date: 07/07/26
 QA: N/C Closed: Yes Date: 07.07.26

NCR: 32649-2		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/20	7.0	one wear plate scrap Wear plate was put on wrong side of jig 5000	 QS1012	Scrap to destroy	 07/07/20	 07/07/20	 QS1012	 07/07/20
		Wear plate was put on wrong side of jig weld where not as per dwg. weld was on wrong side						

NOTE: Date & initial all entries

